

Work Order ID 53402

November 03, 2009 3:54:40 PM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 11/4/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: mf Date: 09-11-03 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2221	Rev H

* Base converted for DS1 9473 installation

09.11.04

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M109213

1.5 Drill holes for gas spring in D3825-041 per DS1 9473 (-143) (one side only)

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110



QC

Memo

0.00

Quality Control

09/11/05

PD 09.11.06

SA Eric C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D2221
Revision ID: H
Item Name: 350 Basket Base

Accept



Setup Start



Stop



Start Date: 11/4/2009 Start Qty: 1.00
Required Date: 11/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120
QC
Quality Control

QC6- Inspect dimensions to drawing

0.00

⇒ 807/11/06

(H)

0.00

Memo

130
Powdercoat
Powder Coating

* pressure wash
White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel
11/21/09

0.00

⇒ HP 09/11/09 (X1) ⓧ

0.00

Memo

1- Plug holes prior to

1ST COAT:
START TIME: 11:00AM
OVEN TEMPERATURE: 400°F
FINISH TIME: 11:30AM
***** 2nd coat if necessary*****
2ND COAT:
START TIME: 11:30AM
OVEN TEMPERATURE: 400°F
FINISH TIME: 12:00PM

W/O:		WORK ORDER CHANGES					
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Setup Start



Revision ID: H

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Item Name: 350 Basket Base

Start Date: 11/4/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00

*OK 09-11-10**0.*

QC

Memo

PM 33 355' L

0.00

Quality Control

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/12 HJ
MF 09-11-12.

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 53402

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Comments:

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH  Rib		Manufactured	No			100	Each	23.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

22

51872

10

53213

12

SAD 09-11-05

D2221-5RevH



Rib

Manufactured No

100

Each

6.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

53131

6

1x 09/11/04

SAD 09-11-05

D2221-7RevH



Rib

Manufactured No

100

Each

3.0000

1.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

3

51251

3

2x 09/11/04

SAD 09-11-05

1x 09/11/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 53402



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	7.0000	2.0000			
Basket Hinge											SAD 09-11-05	

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

7

53344

1x

50024

2

51870

5

1x

24 09/11/09

D2235-1RevB1

Manufactured

No

100

Each

16.0000

2.0000



Basket Rib

SAD 09-11-05

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

3

51438

3

Main Warehouse

WA

13

50565

3

51871

10

2x

24 09/11/09

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Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

Work Order ID: 53402

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base



Comments:

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1  Mounting Bracket		Manufactured	No			100	Each	56.0000	2.0000 		<i>SAD 09-11-05</i>	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 12

46086 2

48428 1

51120 9

Main Warehouse

WA 44

50872 1

51745 43

D3442-1RevA

Manufactured No

100

Each

14.0000

2.0000


Shim

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1

46767 1

Main Warehouse

WA 13

50951 13

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Shop Packet Print

Page 3

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Picklist Print

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Work Order ID: 53402

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base



Comments:

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3825-041RevA		Manufactured	No			100	Each	4.0000	2.0000			
												
Rib Assembly (Basket End)												

SAD 09-11-05

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

51869

4

D3826-041RevB

Manufactured

No

100

Each

4.0000

2.0000



Rib / Gusset Assembly

2x 09/11/04

0 SAD 09-11-05

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

51340

4

D3827-041RevA

Manufactured

No

100

Each

3.0000

1.0000



Rib Assembly (Inboard)

2x 09/11/04

SAD 09-11-05

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

51339

3

1x 09/11/04

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Page 4

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

Work Order ID: 53402

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Comments:

Start Date: 11/4/2009

Required Date: 11/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3832-1RevA  Mesh (Base)		Manufactured	No			100	Each	4.0000	1.0000			

SAD 09-11-05

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 2

46306 1

46774 1

Main Warehouse

WA 2

51863 2

D3833-1RevA

Manufactured No

100

Each

12.0000

2.0000



Mesh (Base End Face)

1x SH 09/11/05

SAD 09-11-05

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 4

51304 4

Main Warehouse

WA 8

50025 2

53214 6

2x SH 09/11/05

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Shop Packet Print

Page 5

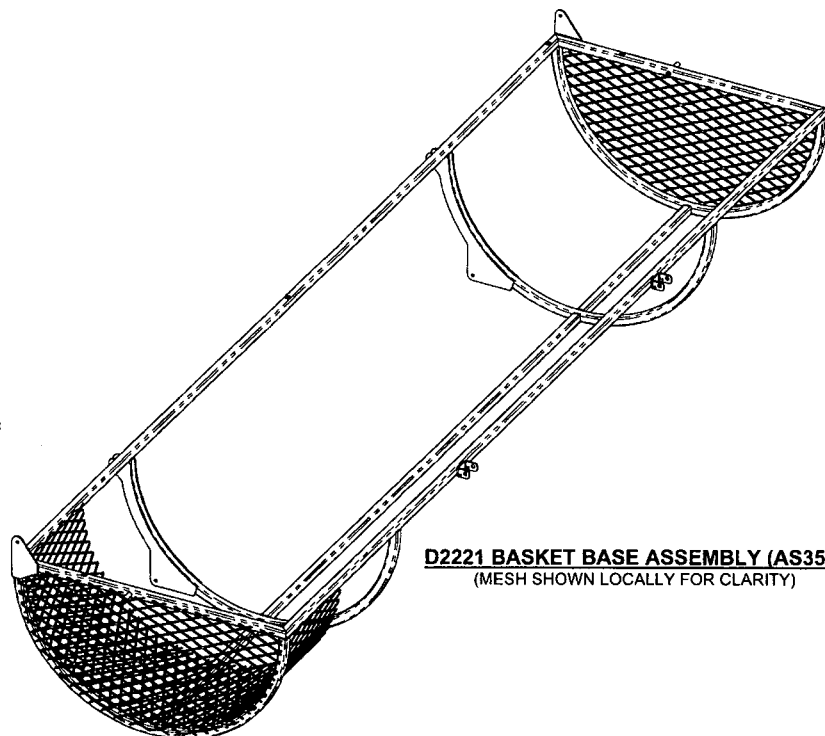
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C8-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.18
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

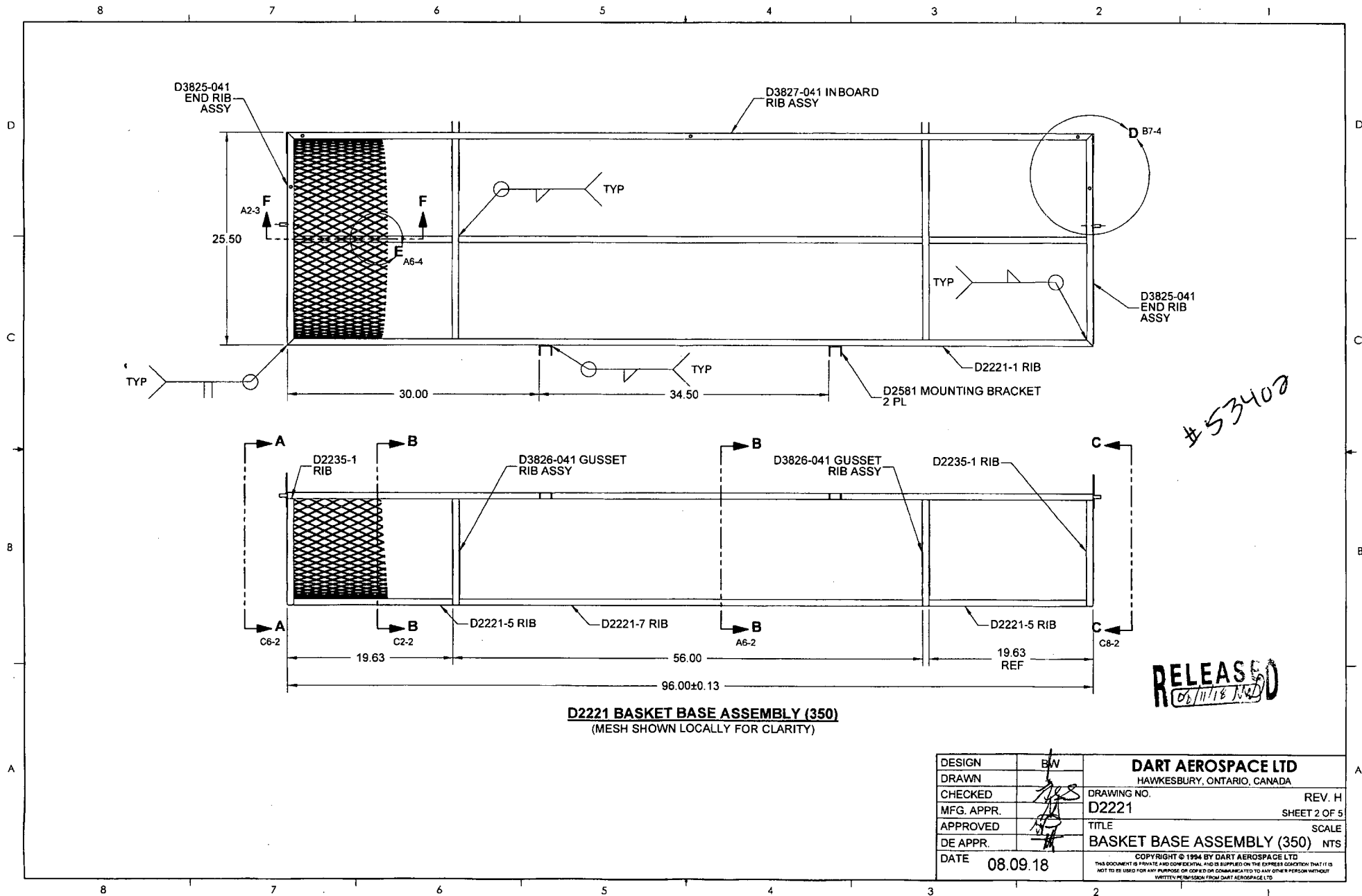
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NOTE: Date & initial all entries



DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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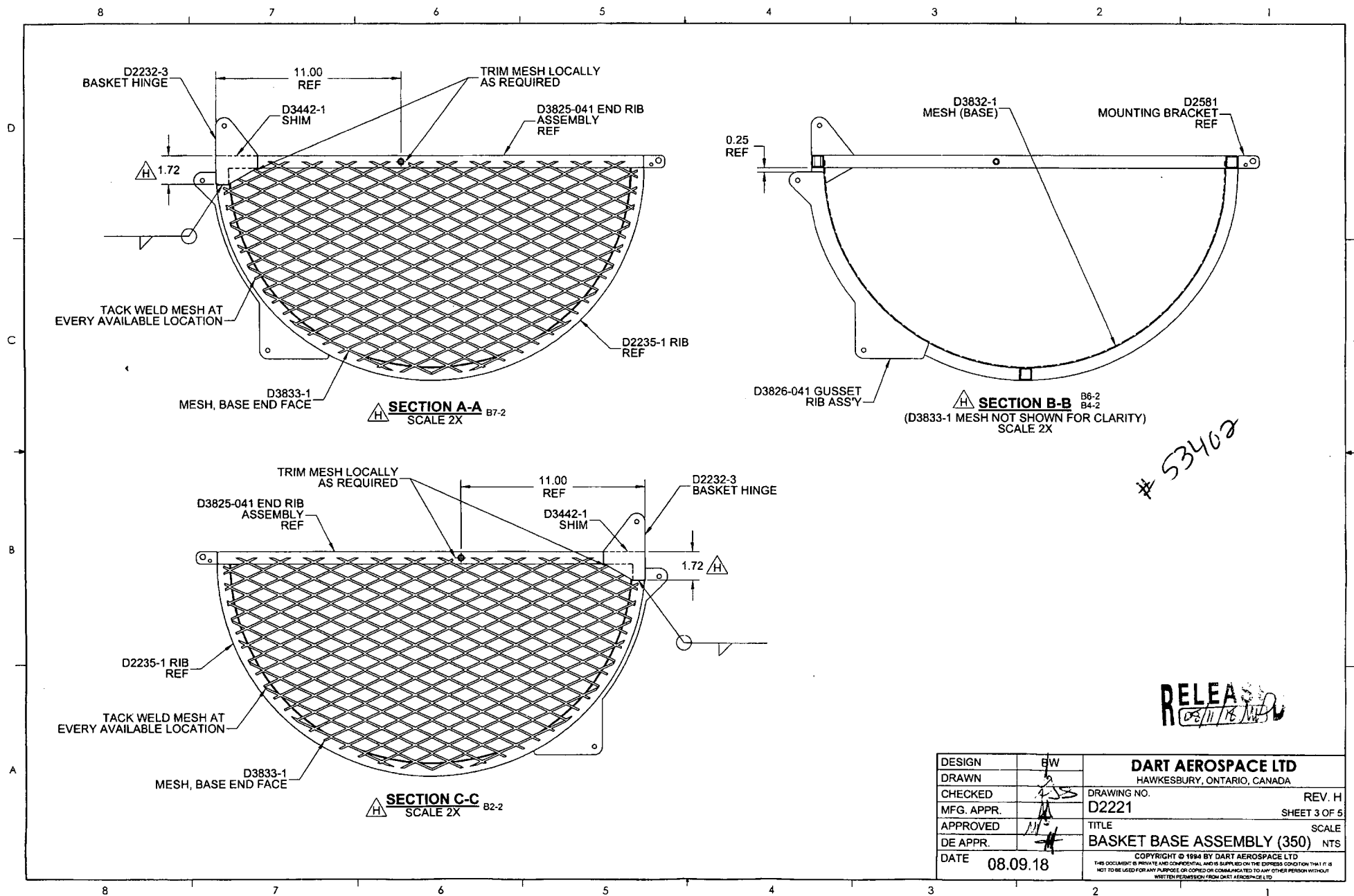
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASE
03/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2221	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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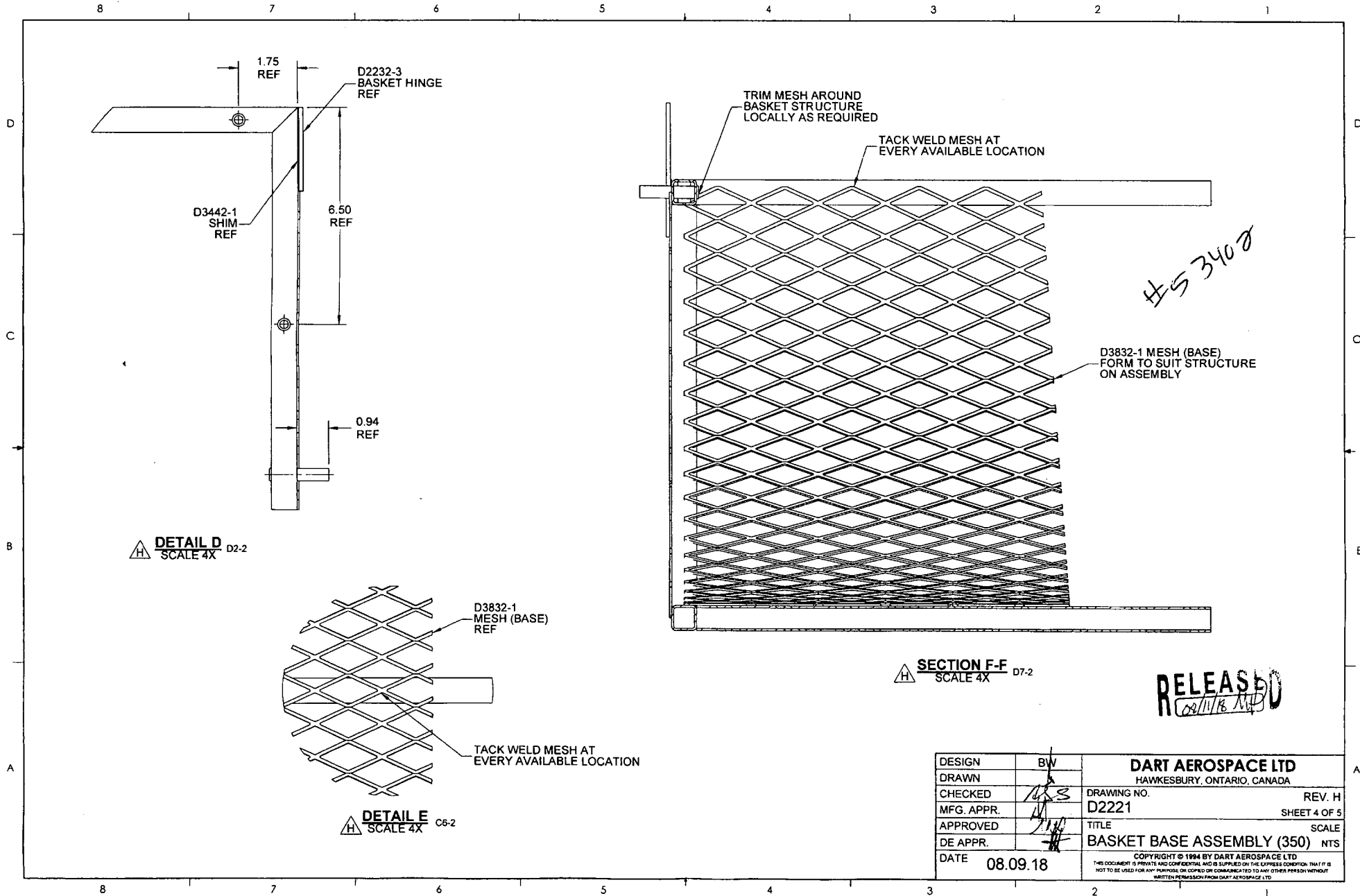
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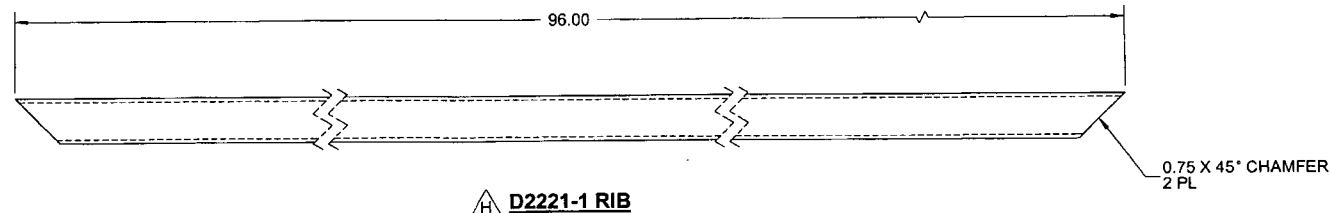
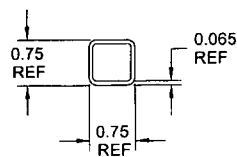
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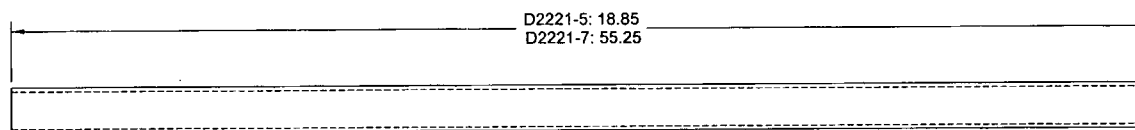
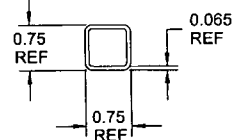
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D2221-1 RIB

53402



D2221-5/-7 RIB

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	AS	D2221	SHEET 5 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	W	BASKET BASE ASSEMBLY (350) NTS	
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries